

Work Order ID 109861

December-03-13 2:55:47 PM

\*109861\*

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Item ID: D2010-104 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: ARM  
 Start Date: 12/03/13 Start Qty: 6.00 \*6\* Cust Item ID:  
 Required Date: 12/06/13 Req'd Qty: 6.00 \*6\* Customer:  
 Reference:

Approvals: Process Plan: ✓ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2010	Rev D								
100	NC BRAKE	0.00							
*100*									
Brake NC	Memo	0.00							
Brake NC	Punch per Dwg. D2010-104 and Spec Control Dwg D2727 Identify as D2010-104								
110	Small Fab	0.00							
*110*									
Small Fab	Memo	0.00							
Small Fab	1- Bend as per Dwg D2010 using bending Jig D2010-104T2 2- Deburr ends								
120	Small Fab	0.00							
*120*									
Small Fab	Memo	0.00							
Small Fab	1- flare before installing plug as per dwg D2010 2- Install D2057 plug as per Dwg D2010								

6 FF 13-12-04  
 6 FF 13-12-04  
 6 FF 13-12-04

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 Start Date: 12/03/13 Start Qty: 6.00 \*6\* Cust Item ID:  
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 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00		DAS 27 9-89 13/12/04		6			
140 *140* Powdercoat Powder Coating	Black Sandtex(Ref 4.3.5.7) per QSI005 4.3 11/26/88 Memo START TIME: 11:30 OVEN TEMPERATURE: 320° FINISH TIME: 2:00	0.00  0.00				6	6	13-12-11	DAS 34 9-89
150 *150* QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00		DAS 27 9-89 13/12/11		6			

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Item ID: D2010-104

Revision ID:

Item Name: ARM

Start Date: 12/03/13 Start Qty: 6.00

Required Date: 12/06/13 Req'd Qty: 6.00

Reference:

Accept

**\*N900040100\***Setup Start **\*NS1\***Stop **\*NS2\***

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: _____	0.00							
<b>*160*</b>									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
<b>*170*</b>									
QC	Memo	0.00							
Quality Control									

DAS  
32  
9-89ME  
13-12-18

# Picklist Print

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Page 1

Work Order ID: 109861

Parent Item: D2010-104

Parent Item Name: ARM

Start Date: 12/03/13

Required Date: 12/06/13

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP A04.02.17New issueKJ/JLM  
IPP Rev:B 08-05-27 as per ECN1195P DD verified by:EC  
IPP Rev:C 08-06-20 rev.D as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TR0.500W.049  
304 RD Tube .500 x .049W

Purchased No

100 f 212.4591

1.5 10

FF 13-12-04

Location	Loc Qty	Loc Code
MAT017	212.459116	
119087	0.000016	
120633	43.66	
123449	84.0547	
125513	24.534	
m126466	60.2104	

10

D2057  
Plug

Manufactured No

110 Each 66.0000

1 6

FF 13-12-04

Location	Loc Qty	Loc Code
GA	1	
75070	1	
ST004	65	
105455	39	
71888	1	
97932	25	

6

8

7

6

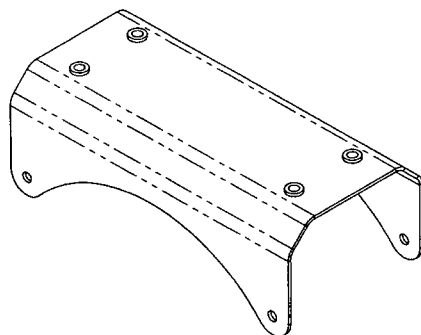
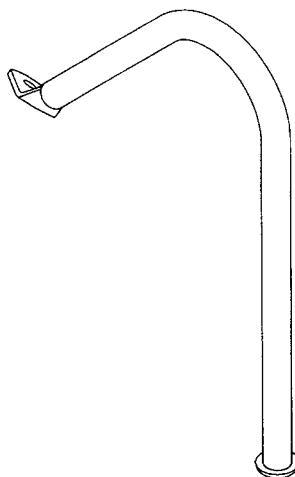
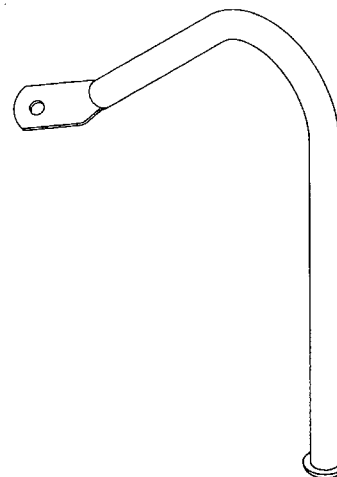
5

4

3

2

1

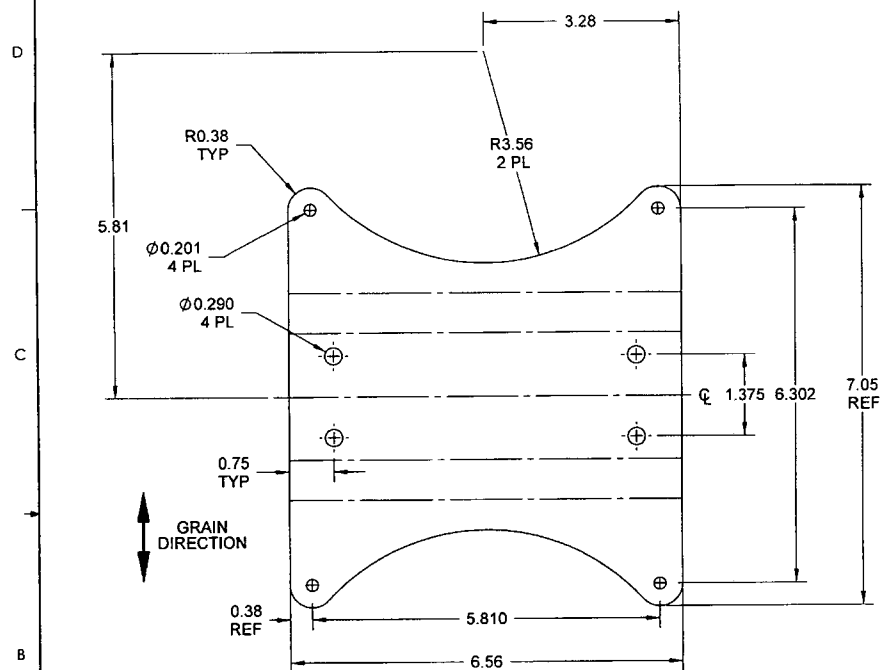
**D2010-101 MIRROR BRACKET****D2010-103 ARM****D2010-104 ARM**

**RELEASED**  
 08.06.10

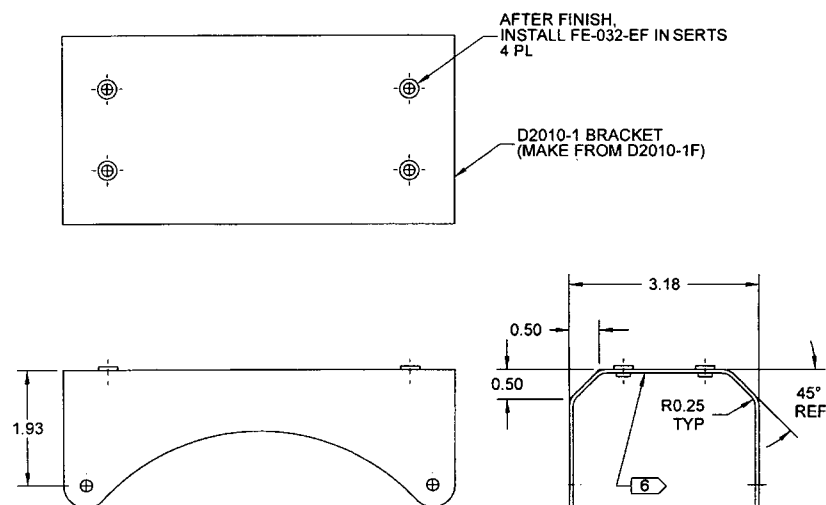
*cto*  
*109861*

D	REDRAWN IN SOLIDWORKS; ADD D2010-1F FLAT PATTERN FOR D2010-101 (ZN B7-2); Ø0.500 X 0.049 WALL WAS Ø0.500 X 0.035 WALL (ZN B1-3, B1-4); REASON: TUBING CRACKING DURING SERVICE		PH	08.06.10
C	1.93 WAS 2.00; 0.50 WAS 0.62		KE	97.10.31
B	7.90 WAS 10.90		JB	92.03.17
A	NEW ISSUE		JB	90.12.15
REV.	DESCRIPTION		BY	DATE
DESIGN	JB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D2010</b> REV. D SHEET 1 OF 4 TITLE <b>MIRROR BRACKET</b> SCALE NTS COPYRIGHT © 1990 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		
DRAWN	PH			
CHECKED	PH			
MFG. APPR.	PH			
APPROVED	PH			
DE APPR.	PH	DATE <b>08.06.10</b>		

QTY -101	P/N	DESCRIPTION
X	D2010-101	MIRROR BRACKET
1	D2010-1	BRACKET
4	FE-032-EF	INSERT



**D2010-1F FLAT PATTERN** 



D2010-101 MIRROR BRACKET

RELEASE  
78-06-19/10

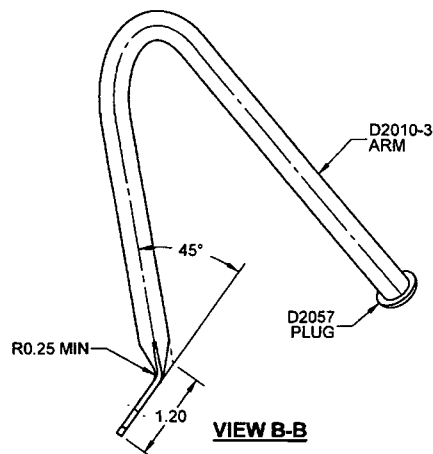
NOTES:

- NOTES:**
- 1) MATERIAL: D2010-1F: 2024-T3 ALUMINUM SHEET, 0.063 THICK PER AMS-QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.063)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2010-101" USING WHITE FINE POINT PERMANENT INK MARKER OR LABEL
  - 7) WEIGHT: 0.23 lbs

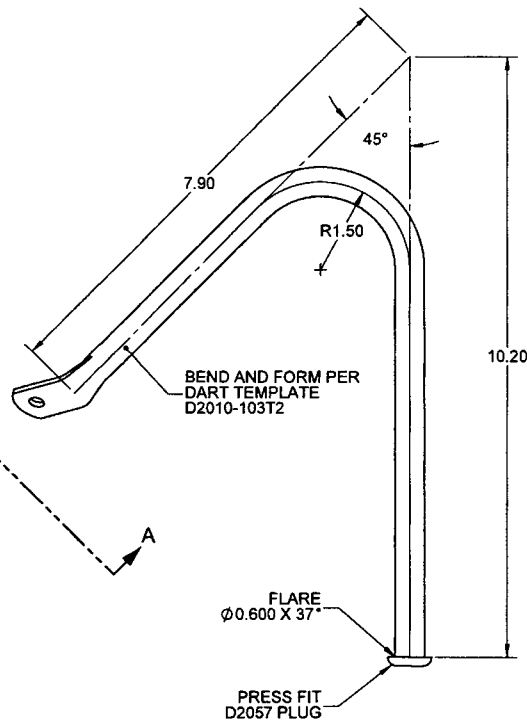
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CHECKED	<i>JB</i>	DRAWING NO.	REV.
MFG. APPR.	<i>JB</i>	D2010	SHEET 2 OF
APPROVED	<i>JB</i>	TITLE	SCALE
DE APPR.	<i>JB</i>	MIRROR BRACKET	NT
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8 7 6 5 4 3 2 1

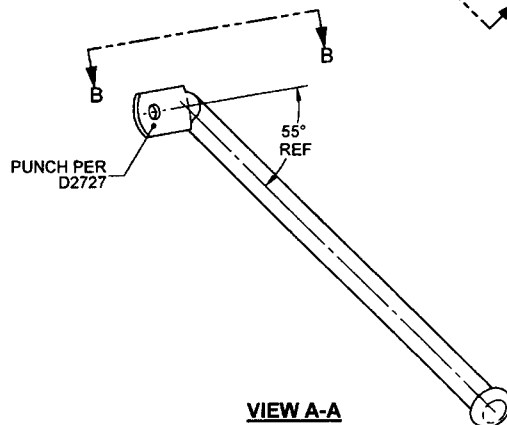
QTY -103	P/N	DESCRIPTION
X	D2010-103	ARM
1	D2010-3	ARM
1	D2057	PLUG



**VIEW B-B**



**D2010-103 ARM**



**VIEW A-A**

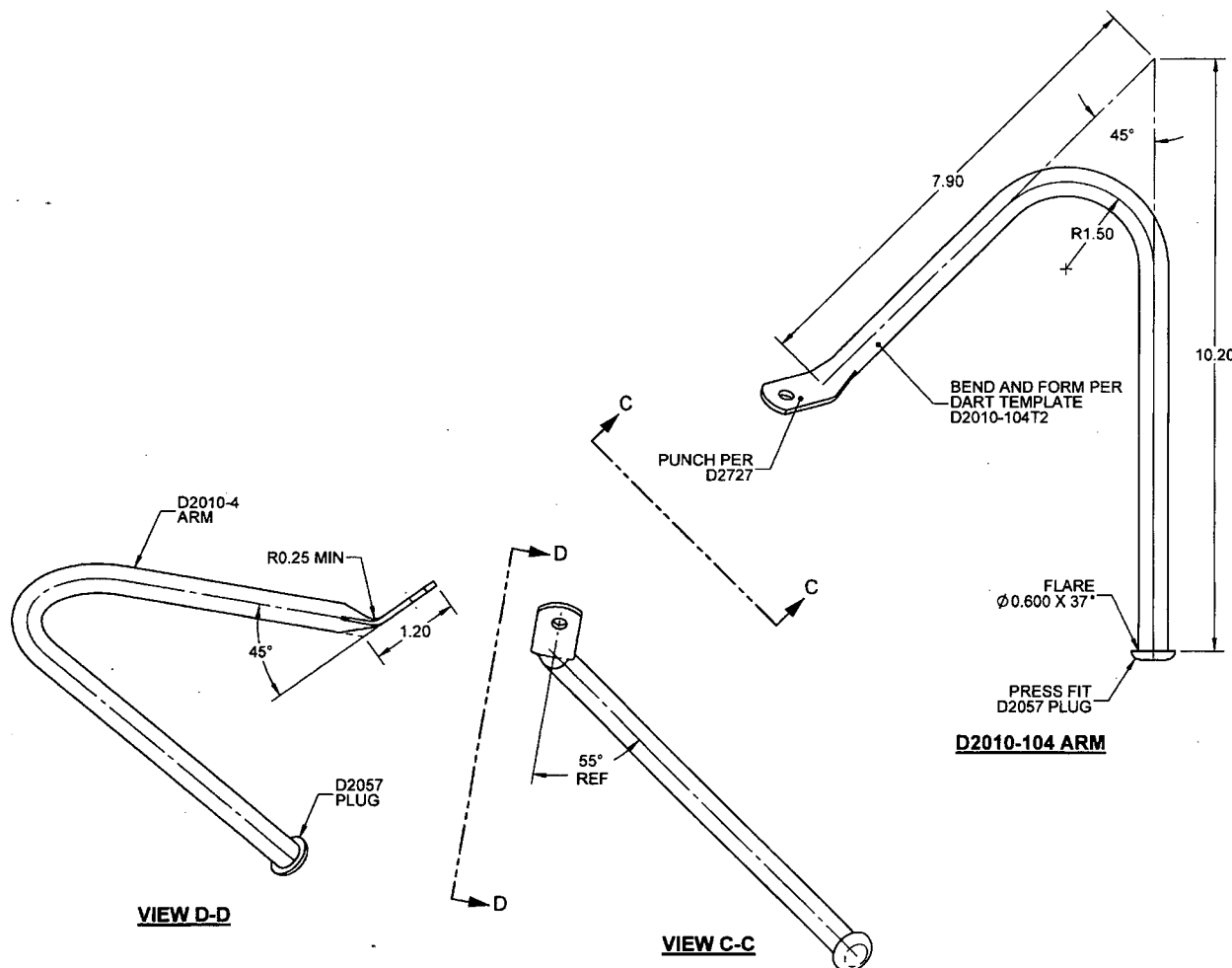
**RELEASED**  
08.06.10

- NOTES:**
- 1) MATERIAL: D2010-3: AISI 304/316 SS SEAMLESS ROUND TUBING, Ø0.500 X 0.049 WALL (REF DART SPEC M304TR0.500W.049)  $\Delta$
  - 2) FINISH: POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2010-103" USING WHITE FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.34 lbs

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8 7 6 5 4 3 2 1

QTY -104	P/N	DESCRIPTION
X	D2010-104	ARM
1	D2010-4	ARM
1	D2057	PLUG



**RELEASED**  
08-06-10

- NOTES:
- 1) MATERIAL: D2010-4: AISI 304/316 SS SEAMLESS ROUND TUBING,  $\varnothing 0.500 \times 0.049$  WALL (REF DART SPEC M304TR0.500W.049)  $\Delta$
  - 2) FINISH: POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2010-104" USING WHITE FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.34 lbs

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